

Date: Wednesday, 19/11/2008 2:18:03 PM  
 User: Julie Dawson

## Process Sheet

|                                                       |                                        |
|-------------------------------------------------------|----------------------------------------|
| Customer : CU-DAR001 Dart Helicopters Services        | Drawing Name : SADDLE ASSEMBLY         |
| Job Number : 43556B                                   |                                        |
| Estimate Number : 11180                               |                                        |
| P.O. Number :                                         | Part Number : D2282043                 |
| This Issue : 19/11/2008 S.O. No. :                    | Drawing Number : D2282 REV E           |
| Prsht Rev. : NC                                       | Project Number : N/A                   |
| First Issue : / / Type : SMALL /MED FAB               | Drawing Revision : E                   |
| Previous Run : 43401B                                 | Material :                             |
| Written By :                                          | Due Date : 05/01/2009 Qty: 50 Um: Each |
| Checked & Approved By : <u>JLD 08-11-19</u>           |                                        |
| Comment : Est Rev:A Removed from 9 Digit 05-12-02 JLM |                                        |

## Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

1.0

D2281

Jack Saddle



Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D2281 Saddle ~~2281~~ = 50 x.

SP 09.03.2.

2.0

D2282

Tube



Comment: Qty.: 2.0000 Each(s)/Unit Total : 100.0000 Each(s)

Pick:

Qty Part Number Description Batch

2 D2282-7 tube ~~2282-7~~ = 20 x.

SP 09.03.2.

3.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per D2282-043 Saddle Assembly

A/R ER316L SS

Filling Rod

Dwg Rev: E

M 108775  
 M 106115

50x  
 SP 09.03.04.

4.0

SMALL FAB 1

SMALL &amp; MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- grind weld flush, take all welding marks out and deburr holes

50x  
 M-1 09/04/20

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

Date: Wednesday, 19/11/2008 2:18:03 PM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE ASSEMBLY

Job Number: 43556B

Part Number: D2282043

Job Number:



Seq. #: Machine Or Operation: Description :

5.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

*lpl 09.04.20*

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*Sorley 09/04/20 counter*

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-tumble

*B 9-4-22*

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*SB 09/04/22 SD*

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *SK*

*SB 09/04/22 SD*

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*09/04/22*

Job Completion



*MF 09-04-22*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |




Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

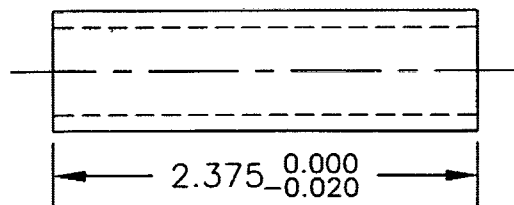
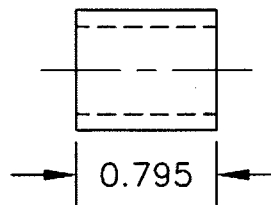
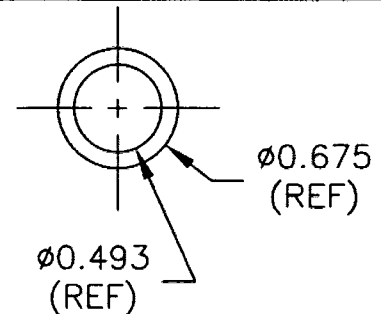
**NOTE:** Date & initial all entries

**DART**

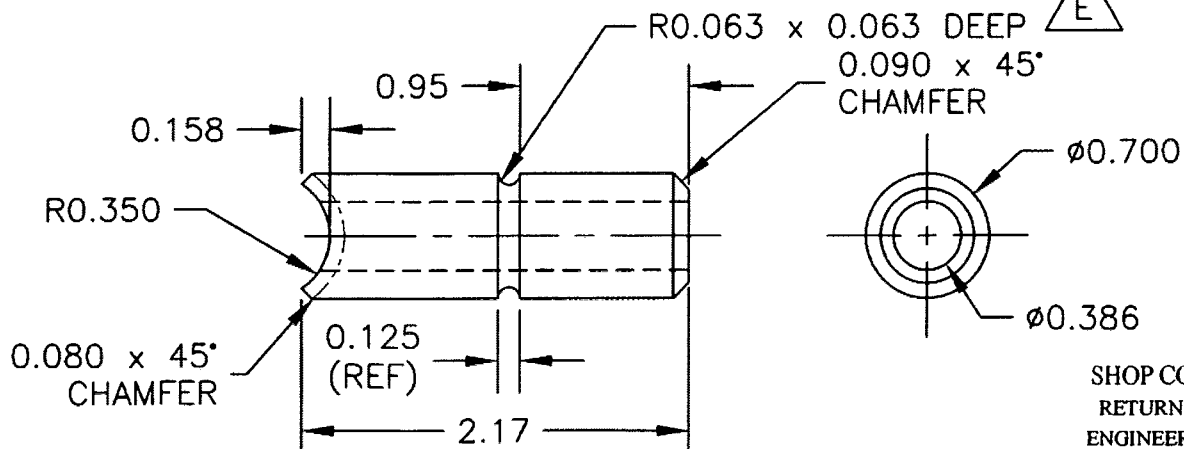
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|----------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------|-----------------------------------------------------------------|------------------------|
| DESIGN<br>BW                                                                                 | DRAWN BY<br> | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA               |                        |
| CHECKED<br> | APPROVED<br> | DRAWING NO.<br>D2282                                            | REV. E<br>SHEET 1 OF 2 |
| DATE<br>05.06.07                                                                             | TITLE<br>HANDLE TUBES                                                                         |                                                                 | SCALE<br>1:1           |
| A                                                                                            | 94.10.14                                                                                      | NEW ISSUE                                                       |                        |
| B                                                                                            | 95.03.23                                                                                      | RE-DESIGN                                                       |                        |
| C                                                                                            | 97.10.20                                                                                      | CORRECTED NUMBERING SCHEME                                      |                        |
| D                                                                                            | 05.03.16                                                                                      | REDESIGN D2282-5; 0.795 WAS 0.750                               |                        |
| E                                                                                            | 05.06.07                                                                                      | D2282-5 304 SS WAS 303 SS;<br>R0.063 x 0.063 WAS R0.080 x 0.030 |                        |

**RELEASED**

05/09/16

**D2282-3****D2282-7****D2282-3/-7 TUBE:**

- 1) MATERIAL: T304/T316 3/8 SCHEDULE 40 (REF. DART SPEC. M304TR0.675W.091)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

**D2282-5****D2282-5 STEM:**

- 1) MATERIAL: AISI 304 STAINLESS STEEL (REF. DART SPEC. M304R0.750)
- 2) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

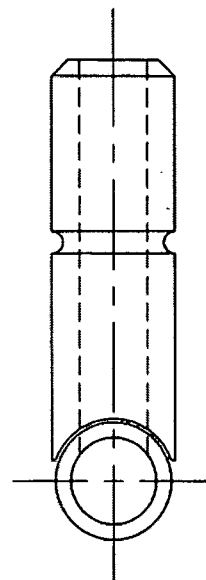
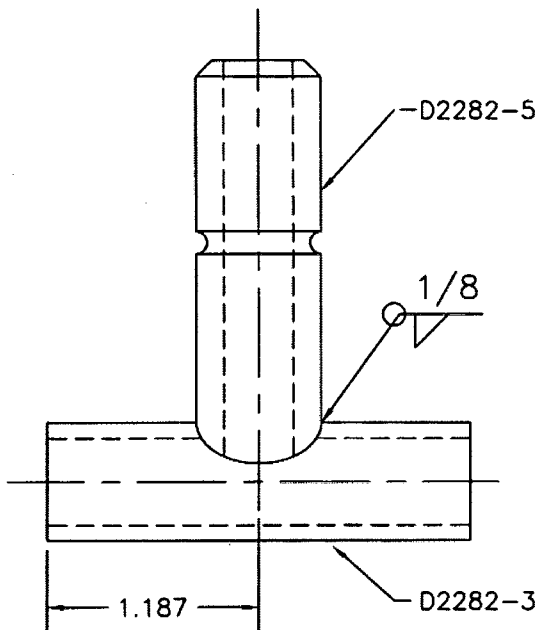
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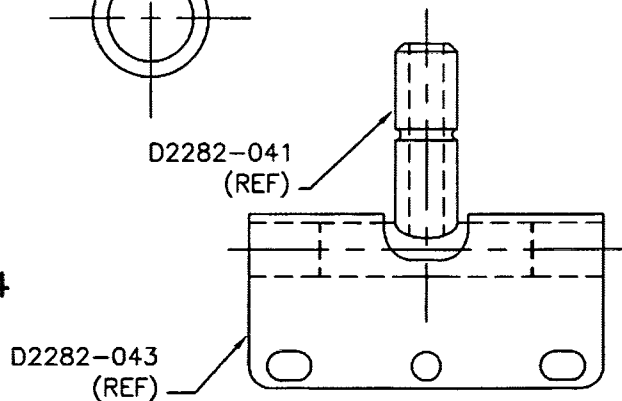


|                               |                                |                                                   |                        |
|-------------------------------|--------------------------------|---------------------------------------------------|------------------------|
| DESIGN<br>BW                  | DRAWN BY<br><i>[Signature]</i> | DART AEROSPACE LTD<br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><i>[Signature]</i> | APPROVED<br><i>[Signature]</i> | DRAWING NO.<br>D2282                              | REV. E<br>SHEET 2 OF 2 |
| DATE<br>05.06.07              | TITLE<br>HANDLE TUBES          |                                                   | SCALE<br>1:1           |

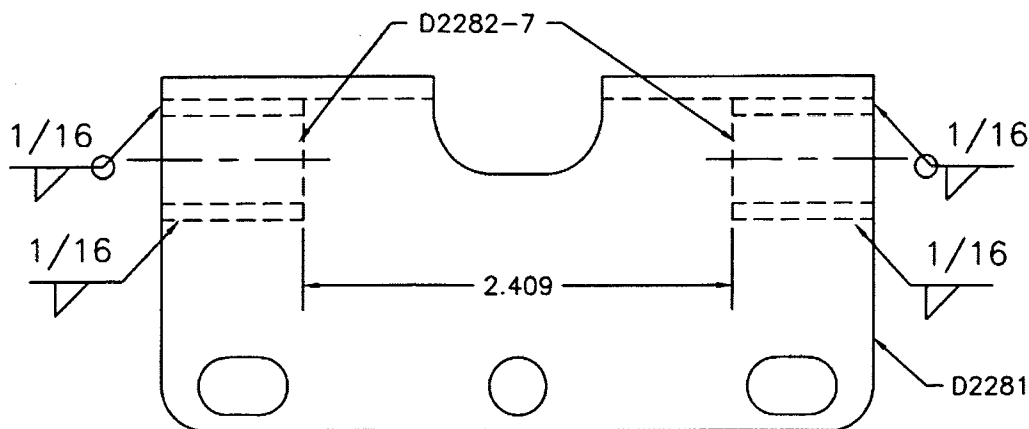


RELEASED  
*[Signature]*  
05/09/16

**D2282-041 'T' ASSEMBLY**  
WELD ASSEMBLY PER DART QSI 004



**GENERAL ASSEMBLY**  
SCALE 1:2



**D2282-043 SADDLE ASSEMBLY**  
WELD ASSEMBLY PER DART QSI 004

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